



Dart Aerospace Ltd.

1270 Aberdeen St

Hawkesbury, ON

K6A 1K7

Canada

Tel (613) 632-5200

Fax 613 632-5246

SWA25A-3-OH

Job Sheet OH196925



Part No: SWA25A-3-OH

Job Qty: 1 pcs

Part Name: Electric Swivel 25,000 lb Safe Work Load (11,340 Kg)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 8/7/19

Created By: Jennifer Renwick

Type: Rework - OH

Description: RA720 / Order / Orig# 2990-01

Note: DWG O&OPM-SWA25A Rev. 2 IPP Rev. A 18.08.05 New issue DP Verify DD

Ship Via:

Order 17523

See Attached

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
110	External Load - Issue SN	1 pcs	8/7/19	8/7/19	0.00	1.00	External Load - 1		
							External Load - 2		5193596
							External Load - 3		
115	External Load - 2 - B4B	1 pcs	8/7/19	8/7/19	0.00	1.00	External Load - 1 - B4B		
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	8/7/19	8/7/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Customer Acceptance	1 pcs	8/7/19	8/7/19	0.00	0.00			
140	Outsource - 2 - NDT per QSI038	1 pcs	8/7/19	8/7/19			SKY002-VC	5	
150	Packaging 2-1 - Receive - B4B	1 pcs	8/7/19	8/7/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		

Plex 6/25/19 11:17 AM Dart.Renwick.Jennife

					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160 QC 6	1 pcs	8/7/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
190 External Load - 4 - B4B	1 pcs	8/7/19	0.00 1.33		External Load - 1 - B4B	
					External Load - 2 - B4B	
					External Load - 3 - B4B	
195 QC 5	1 pcs	8/7/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
200 Packaging 3-1 - Stock - B4B	1 pcs	8/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 DC - 1 - B4B	1 pcs	8/7/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
220 QC 21 - FG	1 pcs	8/7/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	
Part Op 110 - Issue S/N					
Descriptions: 115 - TEST ASSEMBLY. DISASSEMBLE ASSEMBLY. INSPECT DAMAGE PART.					
120 - (QC5- Inspect part completeness to step on W/O)					
140 - LIQUID PENETRANT INSPECTION AS PER QSI 038					
150 - (Receive & Inspect for Damage & Mat'l Certs)					
160 - (QC6- All purchased or subcontracted products) 1-Triage parts to be sent out for plating					
190 - RE-ASSEMBLE. ***All assembly to be done in accordance with manual*** TEST ASSEMBLY.					
195 - (QC5- Inspect part completeness to step on W/O)					
200 - (Identify as per dwg & Stock Location:_____)					
210 - Photocopy blue file manual and create labels					
220 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
SWA25A-3-AR	ELECTRIC SWIVEL 25,000 LB SAFE WORK LOAD (11,340 KG)	1 pcs (1 ea)	110-External Load - Issue SN		
188-FPSS-1032-1/2	Set Screw	1 Ea (1 ea)	190-External Load - 4 - B4B		
188-FPSS-1032-3/8	Set Screw	1 Ea (1 ea)	190-External Load - 4 - B4B		
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	190-External Load - 4 - B4B		
188-FSCS-1032-5/8	Flat socket cap Screw	4 Ea (4 ea)	190-External Load - 4 - B4B		
600.1319	Up Decal	1 pcs (1 ea)	190-External Load - 4 - B4B		
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge replace w/t 01004-08-047	6 ft (6 ea)	190-External Load - 4 - B4B		
SWA10A-1100	Upper DU Bearing	1 pcs (1 ea)	190-External Load - 4 - B4B		
SWA10A-1200	Lower DU Bearing	1 Ea (1 ea)	190-External Load - 4 - B4B		
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	190-External Load - 4 - B4B		
SWA10A-1400	Circlip	1 Ea (1 ea)	190-External Load - 4 - B4B		
SWA10A-400	Thrust Washer	1 pcs (1 ea)	190-External Load - 4 - B4B		
SWA6A-1900	1/4" Female Spade Connector	12 Ea (12 ea)	190-External Load - 4 - B4B		
SWA6A-2000	1/8" Female Spade Connector	4 Ea (4 ea)	190-External Load - 4 - B4B		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-External Load - Issue SN	SWA25A-3	1	0	0	
190-External Load - 4 - B4B	188-FPSS-1032-1/2	1	50	0	
	188-FPSS-1032-3/8	1	78	0	
	188-FPSS-1032-5/8	1	260	0	
	188-FSCS-1032-5/8	4	63	0	
	600.1319	1	235	0	
	EL314-SJTOW	6	0	0	
	SWA10A-1100	1	3	0	
	SWA10A-1200	1	27	0	
	SWA10A-1300	1	12	0	
	SWA10A-1400	1	13	0	
	SWA10A-400	1	14	0	
	SWA6A-1900	12	234	0	
	SWA6A-2000	4	567	0	
Part Specifications					
Specifications could not be found.					

Inspection Sheet Complete
RA720

Customer QA Ref #												0
Part Number	Original Batch / Serial # / Ctrf #	Original Revision #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Original Container #	New (Receiving) Serial #	New Job #	Work order instructions
SWA25A-3	0000 04 AC11005		1	☒ Yes	☐ Yes	☐ Yes	☒ Yes			5193454	CH190110	Overhaul
SWA25A-3	AC11005		1	☒ Yes	☐ Yes	☐ Yes	☒ Yes			5193457		Overhaul
SWA25A-3	AC11003		1	☒ Yes	☐ Yes	☐ Yes	☒ Yes			5193456		Overhaul
0			0	☐ Yes	☐ Yes	☐ Yes	☐ Yes					
0			0	☐ Yes	☐ Yes	☐ Yes	☐ Yes					
0			0	☐ Yes	☐ Yes	☐ Yes	☐ Yes					

QC Approval: 0

Date: 0-Jan-00

Special Return/Rework Instructions:



Electric Swivel
SWA25A

Pre test

Work Order 196925 Customer RA 720

Number of Wires 3 Date 2019-7-4

Serial Number 2990-01

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	25,000	Check for Conductivity against all wires.	- Pass
1	25,000	Check all wires for grounding against swivel body.	- Pass
1	12,500	Check for Conductivity against all wires.	- Pass
1	12,500	Check all wires for grounding against swivel body.	- Pass
1	6,250	Check for Conductivity against all wires.	- Pass
1	6,250	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By: Michael Labonde Signature: _____
Technician QC 5 Small FAB / QA

Submit



Overhaul Incoming Inspection
SWIVEL

Customer OH 196925

Date 2019/07/09

Part Number SWA25A-3

Serial Number 2990-01

Additional Recommended Replacement Parts

Part Number to Replace

Customer Approval

NO SERVICE
PARTS OBSOLETE
+ XTRA WEAR

☐☐☐☐☐☐☐☐☐☐

Inspected By ADJ PATRY

Jennifer Renwick

From: Jennifer Renwick
Sent: Friday, July 12, 2019 10:09 AM
To: Lacey Cantin
Cc: Linda Lacelle
Subject: RE: 25,000 swivels
Attachments: IMG_2669.JPG; IMG_2668.JPG; IMG_2667.JPG

Hi Lacey,

The swivel design is not the same as current design and some of the parts are obsolete. Please see attached pictures for reference.

Pay special attention the file IMG_2668, this bushing is obsolete and our current part is not compatible.

This does happen with some of the old Canam designs.

Thank you,
Jen

From: Lacey Cantin <lcantin@dartaero.com>
Sent: Friday, July 12, 2019 9:46 AM
To: Jennifer Renwick <jrenwick@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>
Subject: RE: 25,000 swivels

Hi Jen,

Would you be able to send me photos and a more detailed explanation as to Order 17523 – OH196925 – SN 2990-01 – Cannot be overhauled? The customer does not understand how this is possible to be beyond economical repair if they can always purchase the parts to replace.

Thanks,
Lacey

From: Lacey Cantin
Sent: July 10, 2019 10:21 AM
To: Jennifer Renwick <jrenwick@dartaero.com>; Caitlin Crooks <ccrooks@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>
Subject: RE: 25,000 swivels

These are mine, I'll reach out and let you know what they want to do ☺

From: Jennifer Renwick
Sent: July 10, 2019 10:18 AM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Lacey Cantin <lcantin@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Subject: RE: 25,000 swivels

Hi Guys,

Please see attached inspection sheets with extra parts needed.

RA720
Order 17523 – OH196925 – SN 2990-01 – Cannot be overhauled
Order 17320 – OH196926 – SN AC11003 – See attached extra parts
Order 17522 – OH196924 – SN AC11005 – See attached extra parts

Thank you,
Jen

From: Jennifer Renwick
Sent: Tuesday, June 25, 2019 11:32 AM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Lacey Cantin <lcantin@dartaero.com>
Subject: FW: 25,000 swivels

Hi Caitlin,

AS discussed, I do not see an order in the system for this one.

Thank you,
Jen

From: Jennifer Renwick
Sent: Tuesday, June 25, 2019 8:28 AM
To: Lacey Cantin <lcantin@dartaero.com>
Cc: Linda Lacelle <llacelle@dartaero.com>
Subject: RE: 25,000 swivels

Hi Lacey,

RA720 has arrived in house. Please flip order to open and use 8weeks, the date may change depending on how many days it takes the customer to provide extra part approval.

Thank you,
Jen

From: Jennifer Renwick
Sent: Tuesday, June 18, 2019 8:12 AM
To: Lacey Cantin <lcantin@dartaero.com>
Subject: RE: 25,000 swivels

Hi Lacey,

Please see attached.

Thank you,
Jen

From: Lacey Cantin <lcantin@dartaero.com>
Sent: Monday, June 17, 2019 8:34 PM
To: Jennifer Renwick <jrenwick@dartaero.com>
Subject: Fwd: 25,000 swivels

Hi Jen,

Can you please issue an RMA for these items?

Thanks!
Lacey

From: Jerry Sullivan <sullivanj@htshelicopters.com>
Sent: Monday, June 17, 2019 7:16:54 PM
To: Caitlin Crooks; Lacey Cantin
Subject: 25,000 swivels

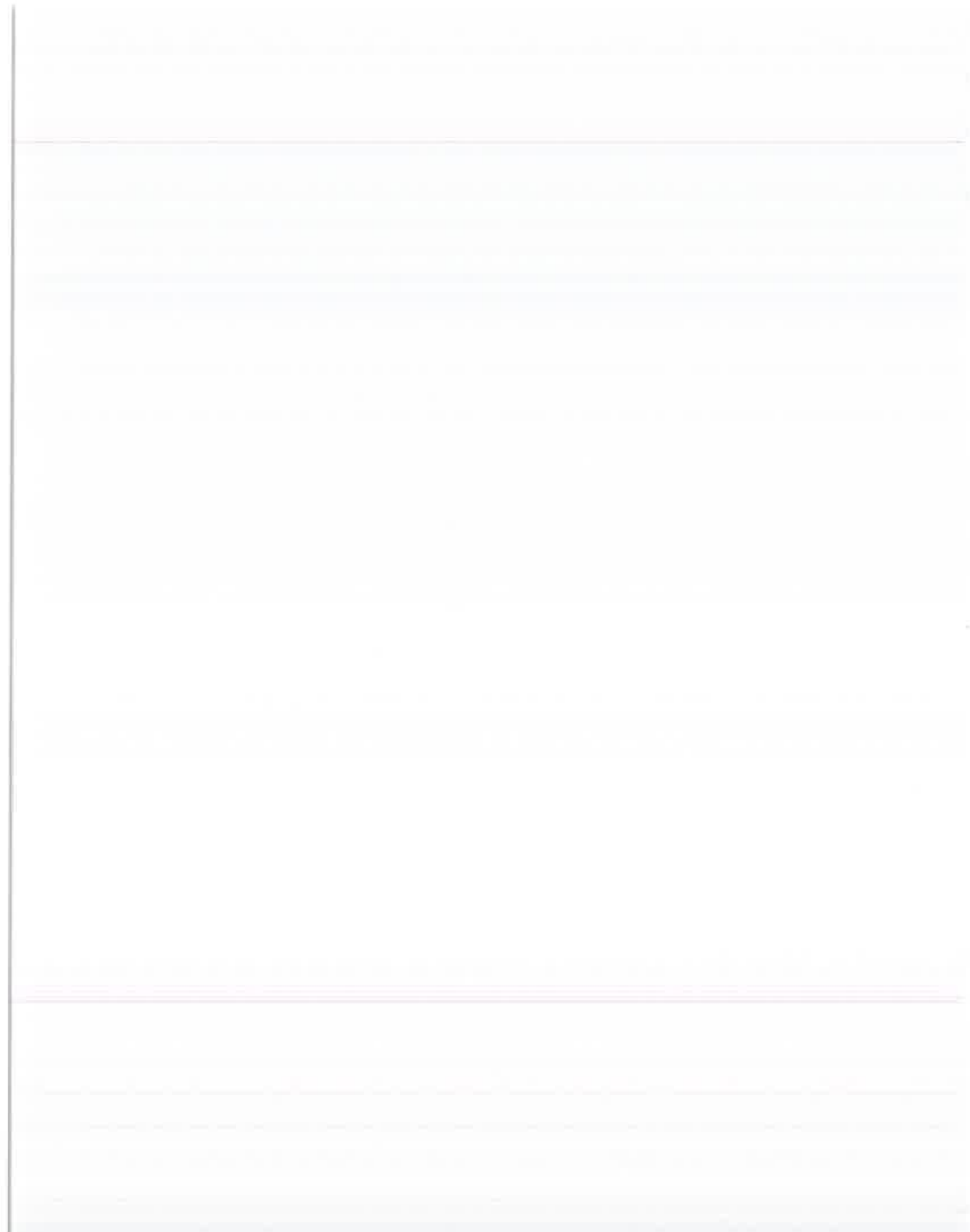
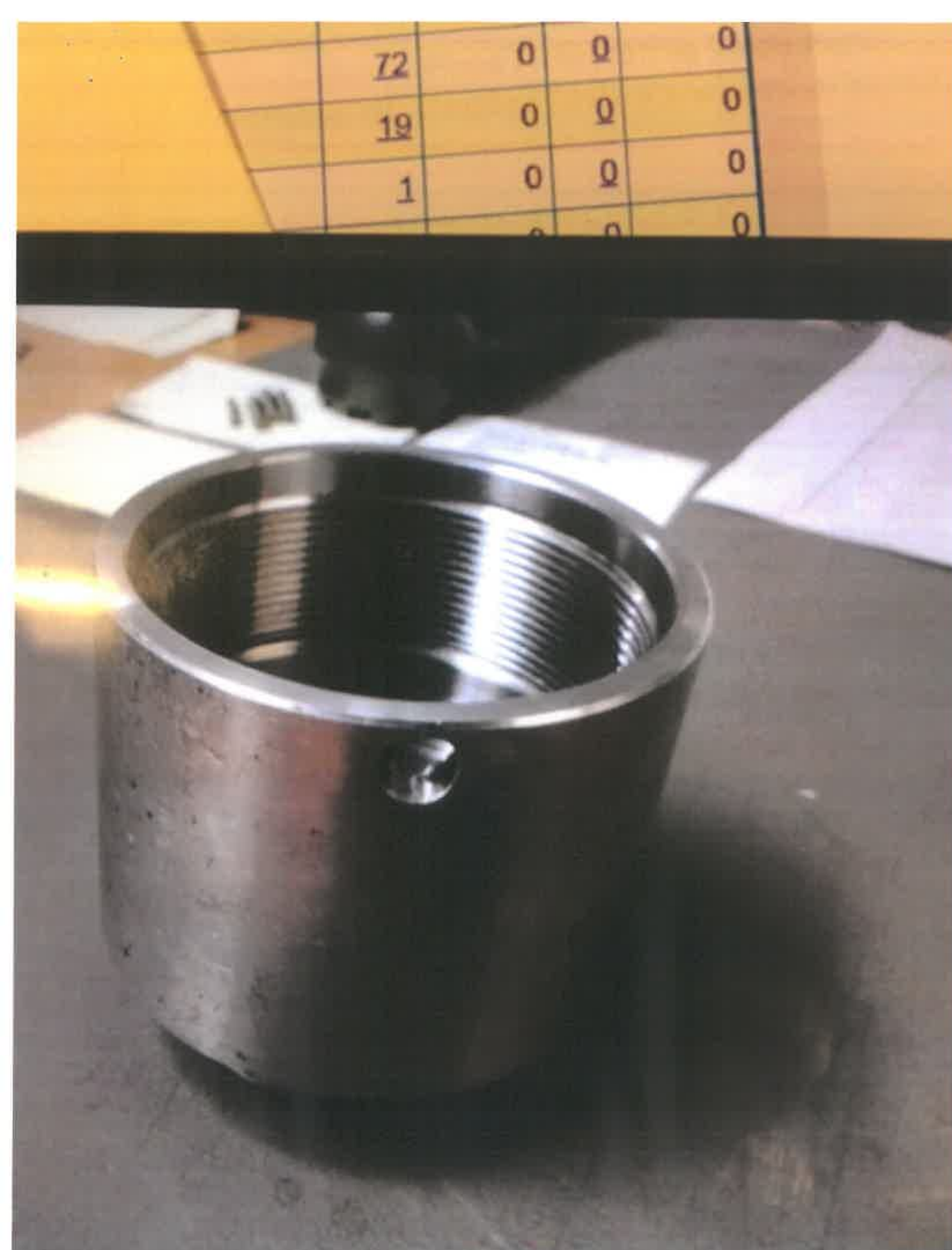
Hello Caitlan and Lacey,
We have 930 25,000 electric swivels that will require overhaul

SWA25A-3 S/N 2990-01
SWA25A-3 S/N AC11005
SWA25A-3 S/N AC11003

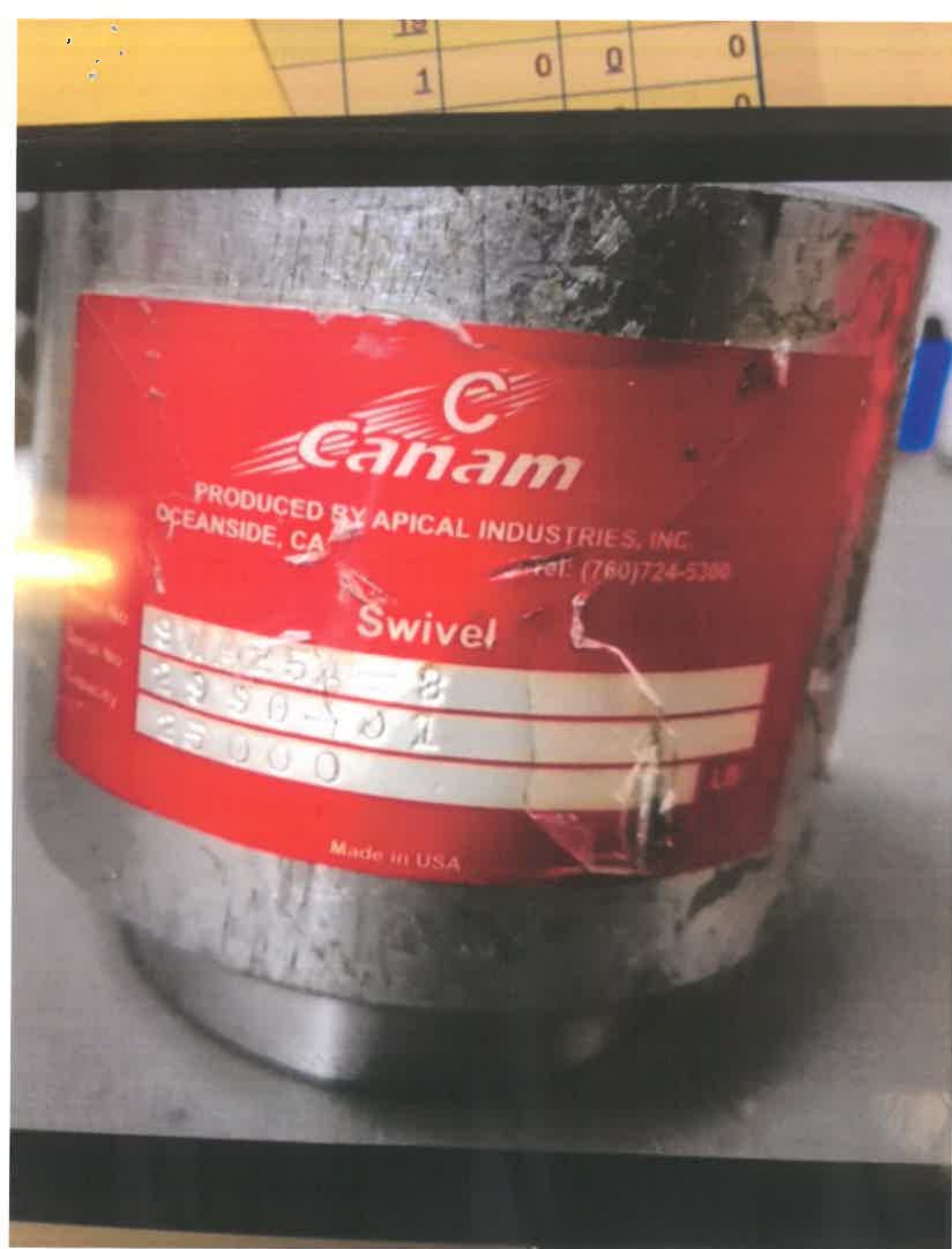
I will also start repair orders on these, and if you could please provide RMA numbers, that would help immensely. Thank you

Jerry Sullivan ext 112
Helicopter Transport Services, LLC
14497 Keil Road NE
Aurora, OR 97002
Ph: 503-776-9300
Fax: 503-776-9305
<http://www.htshelicopters.com/home.php>

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Canam

PRODUCED BY APICAL INDUSTRIES, INC.
OCEANSIDE, CA
Tel: (760) 724-5300

Swivel

25000-2
25000-2
25000-2
25000-2

Made in USA

Jennifer Renwick

From: Jennifer Renwick
Sent: Friday, July 26, 2019 10:17 AM
To: Jean-Luc Menard; Lacey Cantin
Cc: Linda Lacelle
Subject: RE: 25,000 swivels

Okay, Thank you.

Lacey, FYI - orders 17320, 17522 and 17523(not overhauled unit) are shipping today.

Thank you,
Jen

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: Friday, July 26, 2019 9:28 AM
To: Jennifer Renwick <jrenwick@dartaero.com>
Cc: Lacey Cantin <lcantin@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Subject: RE: 25,000 swivels

YES, agree

From: Jennifer Renwick <jrenwick@dartaero.com>
Sent: Friday, July 26, 2019 9:25 AM
To: Jean-Luc Menard <jmenard@dartaero.com>
Cc: Lacey Cantin <lcantin@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Subject: FW: 25,000 swivels

Hi Jean Luc,

We could not overhaul this unit due to design changes (on our end) and the customer did not purchase a new one. I don't believe we should charge them the \$250 inspection fee, do you agree?

Thank you,
Jen

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RA720
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Jerry Sullivan ext 112
Helicopter Transport Services, LLC
14497 Keil Road NE
Aurora, OR 97002
Ph: 503-776-9300
Fax: 503-776-9305
<http://www.htshelicopters.com/home.php>

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